

**\*8688.5\***

July-09-12 9:15:23 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 7/09/12      **Start Qty:** 6.00      **\*6\***

**Cust Item ID:**

**Required Date:** 7/27/12      **Req'd Qty:** 6.00      **\*6\***

**Customer:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

July-09-12 9:15:23 AM

Page 2

mf  
12-08-29

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July-09-12 9:15:23 AM

Page 1

Work Order ID: 86885

Parent Item: D3245-042

Parent Item Name: Access Panel Assembly

Start Date: 7/09/12

Required Date: 7/27/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev :A New Issue 07-09-11 JLM Verified By:EC  
IPP Rev:b ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2350-18-C3Y RIGID RECEPTACLE		Purchased	No			110	Each	57.0000	8	48		7/12/08/29	

Location	Loc Qty	Loc Code
ST399	35	
121499	35	
ST400	22	
105729	2	
19688	20	

D3245-2 Panel		Manufactured	No			110	Each	0.0000	1	6		7/12/08/29	
D3245-5 Door		Manufactured	No			110	Each	26.0000	1	6		7/12/08/29	

Location	Loc Qty	Loc Code
GA	26	
82305	2	
83468	24	

MS20427M3-3 Rivet		Purchased	No			110	Each	1,149.0000	16	96		7/12/08/29	
----------------------	--	-----------	----	--	--	-----	------	------------	----	----	--	------------	--

Location	Loc Qty	Loc Code
GA	1146	
121114	1146	
ST318	3	
120930	3	

MS20615M3-3 Rivet		Purchased	No			110	Each	1,250.0000	9	54		7/12/08/29	
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Location	Loc Qty	Loc Code
ST323	1250	
111650	10	
116188	12	
118384	1228	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

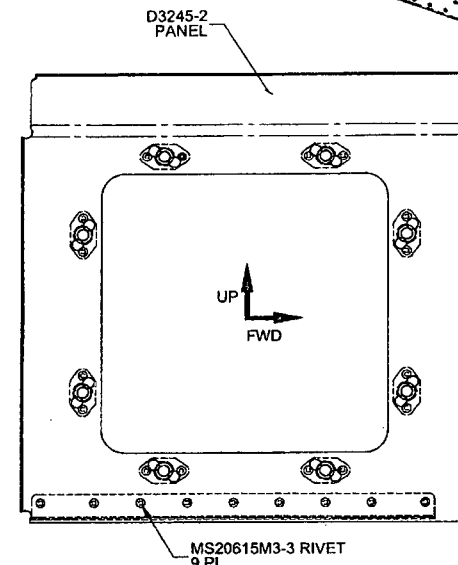
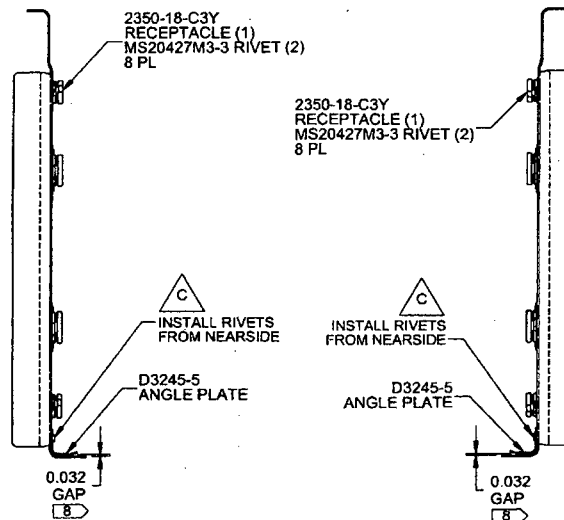
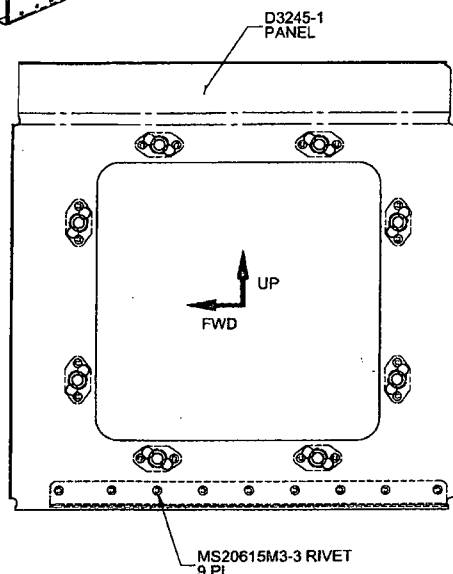
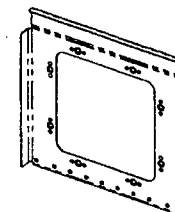
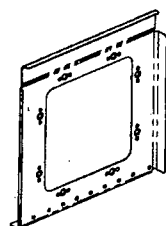
**NOTE:** Date & initial all entries

76885  
 12-07-10

RELEASED  
 2012-05-07

**D3245-041 ACCESS PANEL ASSY (LH)**

**D3245-042 ACCESS PANEL ASSY (RH)**



QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3245-041	ACCESS PANEL ASSY (LH)
		D3245-042	ACCESS PANEL ASSY (RH)
1		D3245-1	PANEL
	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

C	ADDED NOTE & SHEET 1 SPECIFIED RIVET ORIENTATION (B4-1, B5-1) CHANGED 1/4-TURN STUD FROM 2351-20-009-C3Y TO 2351-20-012-C3Y (D5-2). HOLE SIZE WAS 0.096, 9 PLACES (D6-8). HOLE SIZE WAS 0.219, 8 PLACES (D7-5). REF: PAR 12-165.			RP	12.04.11		
	B	REMOVE Ø0.204 HOLES FROM D3245-1/1F; REMOVE MS21060-13K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042; HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING			MB	07.10.02	
		A	NEW ISSUE			RF	04.01.27
		REV.	DESCRIPTION			BY	DATE
DESIGN	RF		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN	MB						
CHECKED	A.P.		DRAWING NO.	REV.			
MFG. APPR.			D3245		SHEET 1 OF 7		
APPROVED			TITLE	SCALE			
DE APPR.			ACCESS PANEL ASSY				
DATE	12.04.11		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ORIGIN OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.				

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
  - 7) WEIGHT: 0.83 lbs
  - 8) TEMPORARILY INSERT A 0.032" GAUGE PLATE PRIOR TO RIVETING D3245-5 TO PANEL



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

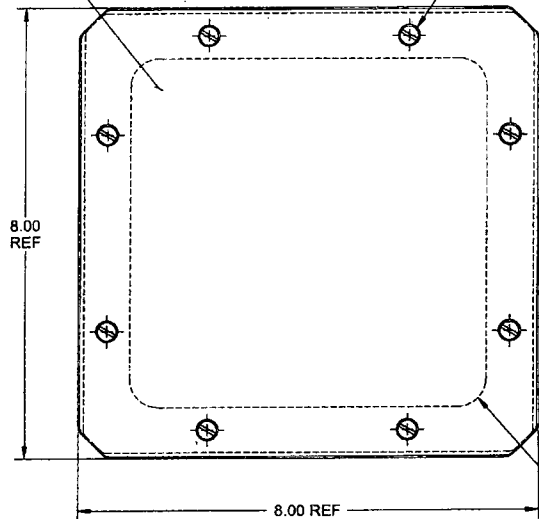
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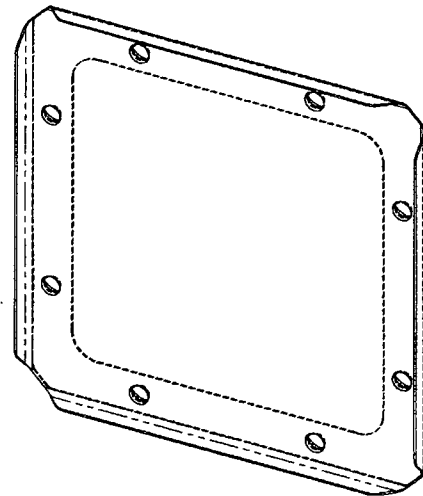
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D3245-3 DOOR

2351-20-012-C3Y STUD  
127H-35 GROMMET  
8 PL



INSTALL D3245-7  
GASKET ON THIS SIDE  
8



D3245-7 GASKET  
REF

**D3245-043 DOOR ASSY**

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	127H-35	GROMMET
8	2351-20-012-C3Y	STUD



**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 9) WEIGHT: 0.72 lbs

*SCF85*

RELEASED  
2012-05-07

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	AP	DRAWING NO. <b>D3245</b>	REV. C
MFG. APPR.			SHEET 2 OF 7
APPROVED		TITLE <b>ACCESS PANEL ASSY</b>	SCALE NTS
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.04.11		

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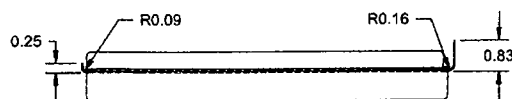
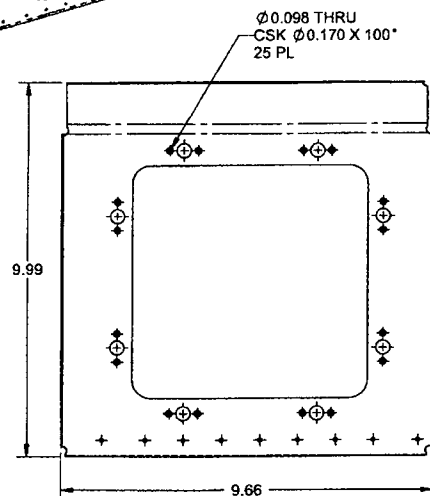
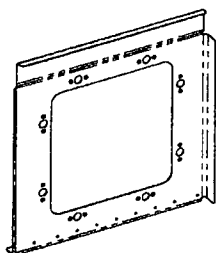
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

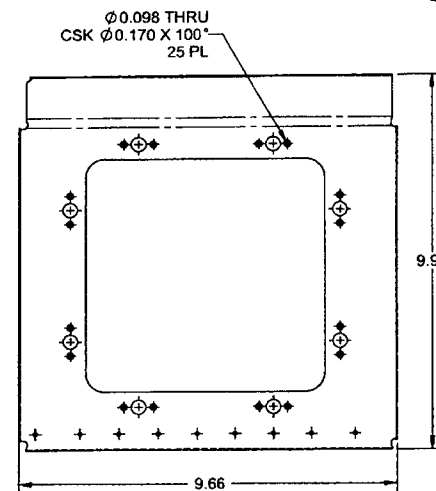
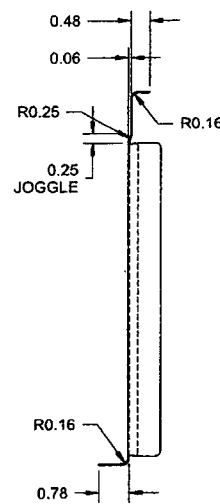
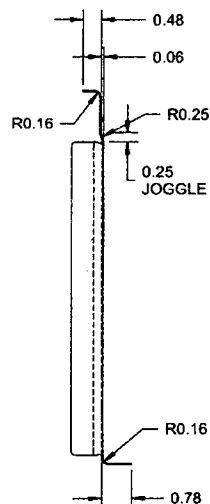
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

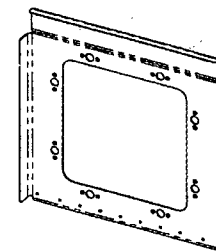
**NOTE:** Date & initial all entries



**D3245-1 PANEL (LH)**



**D3245-2 PANEL (RH)**



- NOTES:**
- 1) MATERIAL: MAKE FROM D3245-1F
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.70 lbs

86885

**RELEASED**  
2012-05-07

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	A.P.	DRAWING NO. <b>D3245</b>	REV. C
MFG. APPR.			SHEET 3 OF 7
APPROVED		TITLE <b>ACCESS PANEL ASSY</b>	SCALE NTS
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.04.11		

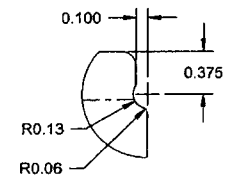
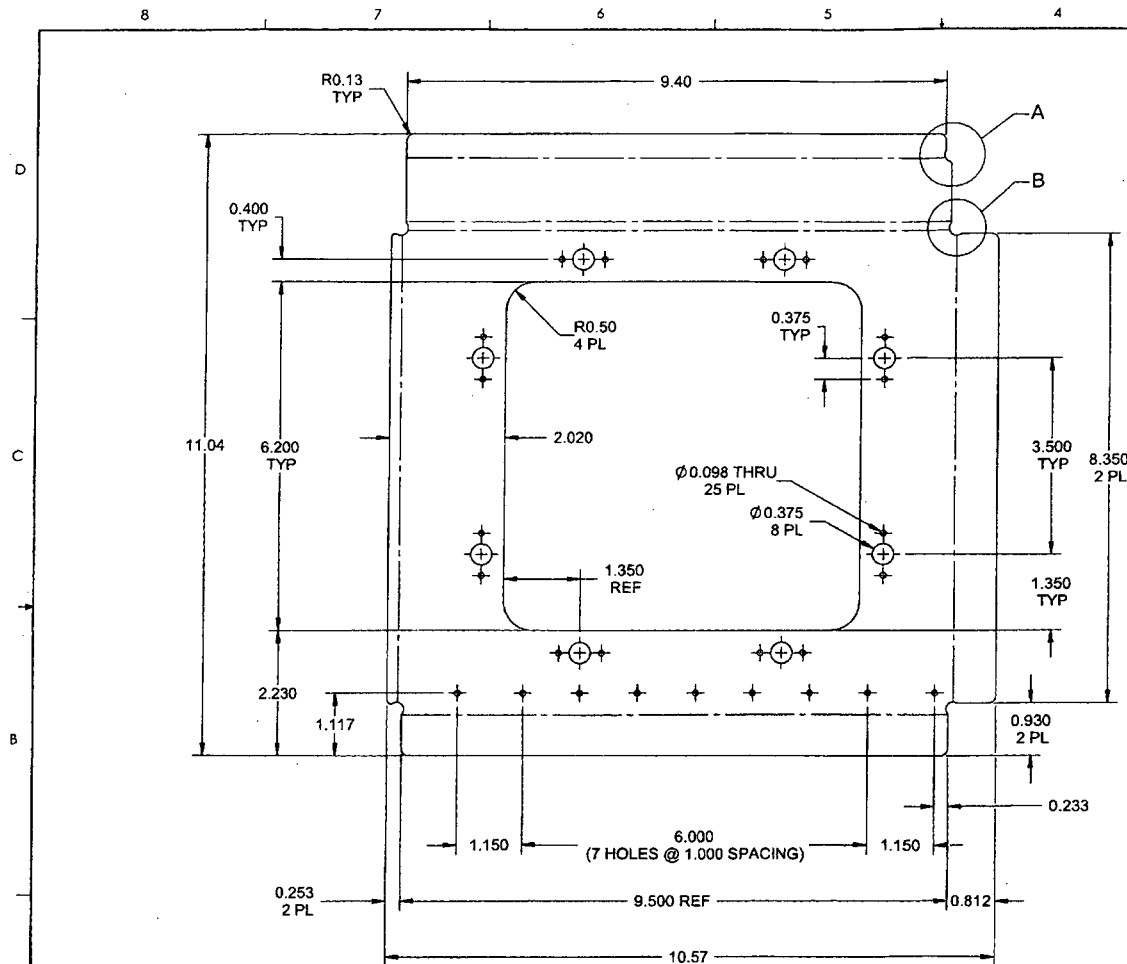
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

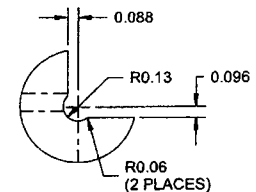
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DETAIL A: RELIEF**  
SCALE 1:1






**DETAIL B: RELIEF**  
SCALE 1:1

RELEASED  
2012-05-07  
W

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

**D3245-1F PANEL FLAT PATTERN**

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.		D3245	SHEET 4 OF 7
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSY	NTS
DATE	12.04.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

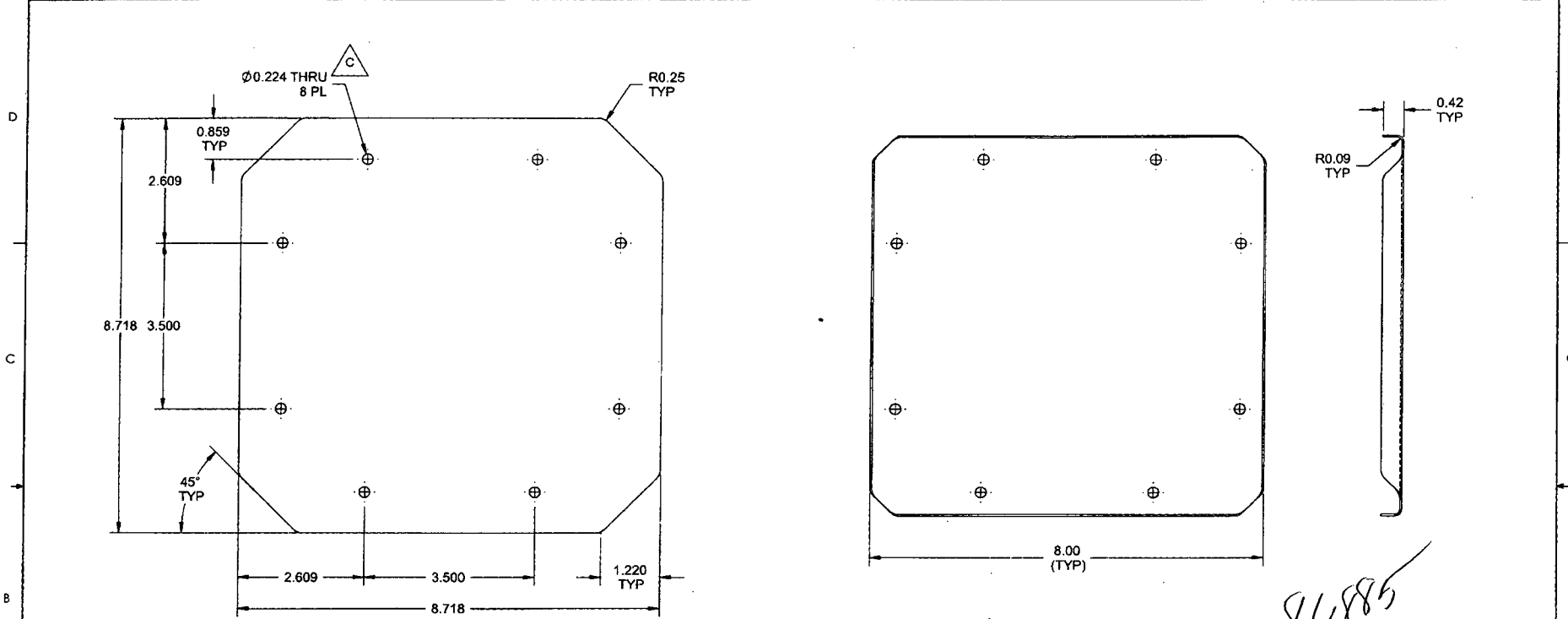
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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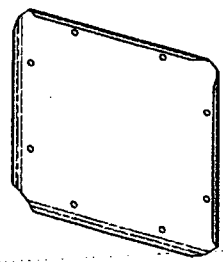
**D3245-3F DOOR FLAT PATTERN**

**D3245-3 DOOR  
(MADE FROM D3245-3F)**

86885

RELEASED  
2012-05-07

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.66 lbs



DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO. <b>D3245</b>	REV. C
MFG. APPR.	AP	SHEET 5 OF 7	
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	<b>ACCESS PANEL ASSY</b>	
DATE	12.04.11	NTS	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1

D

D

C

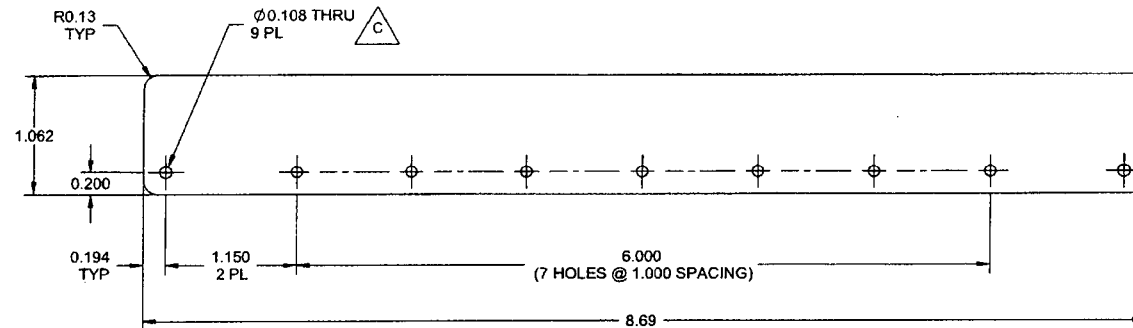
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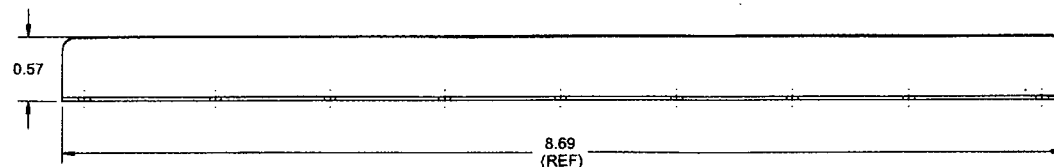
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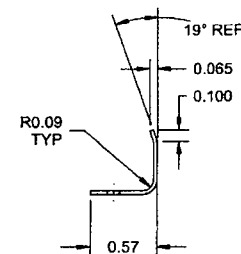
A



**D3245-5F FLAT PATTERN**



**D3245-5 ANGLE PLATE**  
(MAKE FROM D3245-5F)



RELEASED  
2012-07-07  
JAP

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AV	DRAWING NO.	REV. C
MFG. APPR.	ED	<b>D3245</b>	SHEET 6 OF 7
APPROVED	JAP	TITLE	SCALE
DE APPR.	JAP	<b>ACCESS PANEL ASSY</b>	NTS
DATE	12.04.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

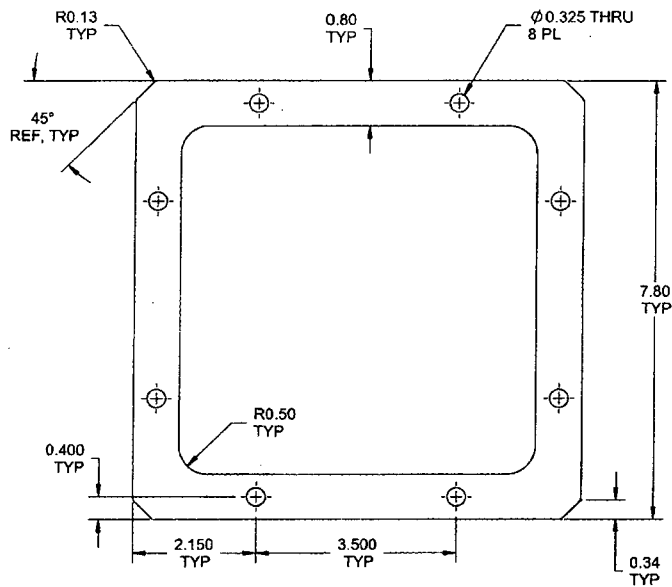
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

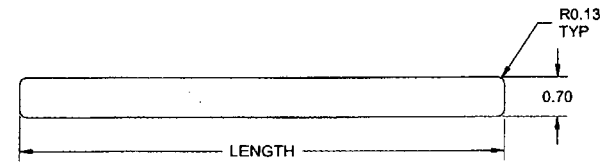
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3245-7 GASKET**



**D3245-X GASKET**

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

**NOTES:**

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK  
PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A OR AMS 3232  
(REF. DART SPEC. MDURAS.035)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MB</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>MB</i>	D3245	SHEET 7 OF 7
APPROVED	<i>MB</i>	TITLE	SCALE
DE APPR.	<i>MB</i>	ACCESS PANEL ASSY	NTS
DATE	12.04.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries